

D206-642-641

Dart Aerospace Ltd.

Date: Friday, 1/25/2008 10:38:44 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FLOAT SKIDTUBE LH 206A/B
Job Number	: 36954		
Estimate Number	: 10801		
P.O. Number	:	Part Number	: D206642611
This Issue	: 1/25/2008 S.O. No. :	Drawing Number	: N/A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1/1 Type : LANDING GEAR	Drawing Revision	: L
Previous Run	: 36952	Material	:
Written By	:	Due Date	: 3/10/2008 Qty: 1 Um: Each
Checked & Approved By	:		
Comment	: Est Rev:B 05.10.27 Revised pick list KJ/EC Est Rev:C 07-12-05 ECN 1080p Rev:L DD verified by:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-611 CHG003

08.02.27
 08/05/22

2.0	36954A	FLOAT SKIDTUBE HIGH GEAR 206 A/B
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Comment: Sub-Component FLOAT SKIDTUBE HIGH GEAR 206 A/B
 D206-642-641 B 36954A

34

3.0	D206651041	206 A/B GHW Kit
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 1 D206-651-041 GHW Kit Batch: B 34773

C

4.0	D2652	Bushing
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Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)
 Pick:

Qty	Part Number	Description	Batch
16	D2652	Bushing	B 38745

C

5.0	D26651	Saddle, LH Fwd Aft Out
-----	--------	------------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Pick:

Qty	Part Number	Description	Batch
2	D2665-1	Saddle	B 35803

8/5/12 ①

B 37330 1X

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE LH 206AB

Job Number: 36954

Part Number: D206642611

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D26661

Saddle, LH, Fwd,Aft, In



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2666-1 Saddle

B 36185

lc

7.0

D2712

Set Screw



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number Description Batch

10 D2712 Set Screw

B 34628

lc

8.0

D2884

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2884 Saddle Spacer

B 35497

lc

9.0

D2885

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2885 Saddle Spacer

B 37342

lc

10.0

D33963

Inventory



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3396-3 Spacer

B 36336

lc

11.0

AN3C36A

BOLT



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number Description Batch

6 AN3C36A Bolt

M106541

lc 8/5/12(1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Job Number: 36954

Part Number: D206642611

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

MS21250 03004

HIGH STEEL BOLT



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

HIGH STEEL BOLT

batch M106277

13.0

D36721

PHENOLIC WASHER



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

PHENOLIC WASHER

batch B33470

14.0

AN4C6A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 AN4C6A Bolt M106019

15.0

AN5C7A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN5C7A Bolt M18185

16.0

AN5C11A



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN5C11A Bolt M107013

17.0

AN5C32A



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN5C32A Bolt M105746 34 *

M107013 10

W/O:		WORK ORDER CHANGES					
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE LH 206AB

Job Number: 36954

Part Number: D206642611

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

AN5C35A



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batc

1 AN5C35A Bolt M167501

[Signature]

19.0

AN5C13A



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

bolt

batch M152615

[Signature]

20.0

AN6C44A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batc

2 AN6C44A Bolt M107688

[Signature] 8/5/9

21.0

AN3C41A

BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

BOLT

batch 108084

8/5/21 SD

22.0

AN960C10L

washer



Comment: Qty.: 30.0000 Each(s)/Unit Total : 30.0000 Each(s)

Pick:

Qty Part Number Description Batch

30 AN960C10L Washer M107534

[Signature]

23.0

AN960C416L

WASHER



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number Description Batch

24 AN960C416L Washer M107650

[Signature] 8/5/9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Job Number: 36954

Part Number: D206642611

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

AN960C516L

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 AN960C516L Washer M1D 3344

25.0

AN960C616

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN960C616 Bolt M19185

26.0

MS210433

Nut



Comment: Qty.: 17.0000 Each(s)/Unit Total : 17.0000 Each(s)

Pick:

Qty Part Number Description Batch

17 MS21043-3Nut M107288

27.0

MS210434

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 MS21043-4Nut M107288

28.0

MS210435

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 MS21043-5Nut M106763

29.0

MS210436

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

M107374

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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QA: N/C Closed: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE LH 206A/B

Job Number: 36954

Part Number: D206642611

Job Number:



Seq. #:

Machine Or Operation:

Description :

2 ms21043-6 Nut

30.0

AN960JD10

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Washer

batch M127715

31.0

D36831

INSERT



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

INSERT

batch 31319

32.0

D36727

PHENOLIC WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PHENOLIC WASHER

batch 35522

33.0

D36725

PHENOLIC WASHER



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

PHENOLIC WASHER

batch 35521

34.0

D36723

PHENOLIC WASHER



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

PHENOLIC WASHER

batch 37374

35.0

MS27039C105

SCREW



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

SCREW

batch M136574

PC 8/5/8 ①

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE LH 206A/B

Job Number: 36954

Part Number: D206642611

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

508/05/22 (40)

37.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-642-611

Location: _____

PPP Rev: _____

C

8/15/22

SL

38.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/23

Job Completion



CMF

08-05-22

36954A

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FLOAT SKIDTUBE HIGH GEAR 206 A/B
Job Number : 36954A
Estimate Number : 10803
P.O. Number :
This Issue : 1/25/2008 S.O. No. :
Prsht Rev. : NC Part Number : D206642641
First Issue : 1/1 Type : LANDING GEAR Drawing Number : D3288 REV F U/R
Previous Run : 36952A Drawing Revision : F
Written By : Due Date : 3/10/2008 Qty: 1 Um: Each
Checked & Approved By :
Comment : Est Rev:B 05.11.15 Added washers for aft cap, wearshoes and ring EC
Est Rev:C 06-05-31 Revised steps JLM
Est Rev:D 07-02-22 Added SS Wearplates & Gaskets JLM
Est Rev:E 07-12-06 ECN 1080p DD verified by:

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-641 CHG003

N/A

2.0 D2620 Bent 206 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2620 3" OD Bent Tube B 32449

JB 8-4-1

3.0 D2647 Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2647 Fwd Cap B 35475

BE 08-08-01

4.0 D32861 Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3286-1 Doubler B 33895

(2) 11 8-4-8

W/O:			WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE				By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE HIGH GEAR 206 A/B

Job Number: 36954A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr FWD edge of tube,grind bending marks.

2-Remove ridge on inside of fwd edge of tube as per Dwg D3288.

3-Weld Fwd Cap as per Dwg D3288,Grind to obtain proper fit

A/R AL ROD

Batch: *m106330/m106762 BE 08-04-01*

4-Grind welds flush to cap on top surface only.

5-Cut Aft end as per Dwg D3288 from front of tube then deburr

6-Remove inner indexing ridge on aft end as per Dwg d3288

7-Open holes for aft cap as per Dwg D3288 using Dt8025

8-Drill pilot holes using DT8818

9-Insert D3286-1 doubler using DT8732 & DT8879 ,then locating doubler off the D3286-1 doubler ,leave Dt8732 for added support

3/16" holes cleco

10-Drill D3286-1 doubler rivet holes in tube using #40 drill,spot drilling doubler at the same time.

11-Working from center out,drill #30 holes into D3286-1 Doubler.cleco each hole after its drilled,Verify angle of holes to accomodate rivet heads.

12-Remove 3/16" clecos only and open GHW holes to .500" as per Dwg D3288.

13-Remove D3286-1 doubler,identify orientation,deburr then attach to W/O

14-Remove indexing edge as per Dwg D3288.

15-C'sink rivet holes as per Dwg D3288.

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/04/08 EC

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE HIGH GEAR 206 A/B

Job Number: 36954A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL 08/04/10 ①

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

A.M 08.04.11 ①

9.0

CR3212404

Cherry Rivet



Comment: Qty.: 52.0000 Each(s)/Unit Total : 52.0000 Each(s)

Pick:

Qty Part Number

Description Batch

52 CR3212-4-04 Rivet

M 107478

⑤ H 8-4-11

10.0

D3289041

Float Web (206A/B)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3289-041 Float Web

B 36187

① H 8-4-11

11.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open Holes to finished size as per DWg D3288.Deburr.

2-Locate, install and rivet doublers as per Dwg D3288. Micro-shave rivets as required.

3-Bond web in place as per Dwg D3288 & QSI 015.

A/R Sikaflex-291

M 107397

Sikaflex expire date:

8-7-31

Start: 8-4-11

Time: 8:55

Finish: 8/4/14

Time: 6:45 PM

(Adhere for 12 hours)

H 8-4-11

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

6 08/04/14 ①

W/O:			WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE				By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 36954A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description:

13.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube using program D3288 as per Dwg D3288. Install drop pins in cross bolt spacer holes to maintain web position.

Jb/KL8-414

14.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes for wearplates using D3288-T2 as per Dwg D3288, then open to Ø0.297". (without cutting fluid)

DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES)

2-C'sink X-bolt holes.

3-Deburr

K
7-4-16

15.0

D2649

Crossbolt Spacer



Comment: Qty.: 9.0000 Each(s)/Unit Total: 9.0000 Each(s)

Pick:

Qty Part Number Description Batch

9 D2649 Crossbolt spacer

B37329

BE 08/04/21

16.0

D32751

Crossbolt Spacer



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty Part Number Description Batch

6 D3275-1 Crossbolt spacer

B34619

BE 08/04/21

17.0

D32863

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3286-3

Spacer

B35048

BE 08/04/23

W/O:			WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Drawing Name: FLOAT SKIDTUBE HIGH GEAR 206 A/B

Job Number: 36954A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description:

18.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3288. Remember to back drill each hole before welding the other side. Use aluminum rod.

A/R Aluminum Rod M106330 BE 08/04/21

2-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D3288. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required

A/RSS Rod NONE BE 08/04/23

3-Grind welds flush to Fwd cap on top surface only.

4-Grind cross bolt welds flush as per Dwg D3288. Masking Tape access to inside of the skidtube

5-Counterbore 5/16" x 0.750" deep using DT8747, except 8th cross bolt hole from Aft end, as per Dwg D3288.

PTD →

SL 8-4-21

25 08-04-24

19.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

10 08/04/25

20.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/04/25 BE

21.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

M. 1 08/04/25

836954A
D206642641
28/04/2008

22.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

10 08-04-24

S.131
#1 17.21
#2 321.6 F
#3 302.1 F
#4 F

23.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 08/05/01 ①

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
08.04.25	18	C'BORE, AT LOCATION INDICATED ON ATTACHED DWG DOES NOT NEED TO BE PERFORMED	PH	08.04.25	2	PH Q.S.I. 042 08.04.25	C 08.04.25	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 1/25/2008 10:39:20 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE HIGH GEAR 206 A/B

Job Number: 36954A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

D3415041

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3415-041 Nut Plate

B53842

BR

25.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CCR264SS3-3 Rivet

m106825

BR

26.0

CR3212403

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CR3212-4-03 Rivet

m15918

BR

27.0

ALS71032130

Insert



Comment: Qty.: 64.0000 Each(s)/Unit Total : 64.0000 Each(s)

Insert

Batch: m105819

RV/FZ 08/05/01 @

28.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install D3415-041 Nut Plate as per Dwg D3288 ,Install with LPS-3

A/R LPS-3 Batch: m105005

2-Install inserts Dwg D3288. Use a drop of Sikaflex inside insert holes

A/R Sikaflex-291 m107804

Sikaflex expire date: 08/10

RV/FZ 08/05/01 @

BR 08-05-07 @

W/O:			WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE				By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Friday, 1/25/2008 10:39:20 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE HIGH GEAR 206 A/B

Job Number: 36954A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description:

29.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP
Inserts & Nut plate

a/g 8 00605/02

30.0

D353515

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
WEARSHOE
Batch: *B37810*

BR

31.0

D353521

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
WEARSHOE
Batch: *B31991*

BR

32.0

D353535

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
WEARSHOE
Batch: *B38760*

BR

33.0

D353541

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
WEARSHOE
Batch: *B31993*

BR

34.0

D353615

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
GASKET
Batch: *B33964*

BR

35.0

D353621

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
GASKET
Batch: *B37351*

BR

BR 08-05-07 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 1/25/2008 10:39:20 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE HIGH GEAR 206 A/B

Job Number: 36954A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

D353635

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B37352

BR

37.0

D353641

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B37353

BR

* 38.0

D35371

WEARPAD



Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)

WEARPAD

Batch: B37749

BR

39.0

D35373

WEARPAD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARPAD

Batch: B33881

BR

40.0

AN3C4A

BOLT



Comment: Qty.: 66.0000 Each(s)/Unit Total : 66.0000 Each(s)

BOLT

Batch: B107272

BR

41.0

NAS1515H3L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch: 1710516 107394

BR

42.0

AN960C10L

washer



Comment: Qty.: 78.0000 Each(s)/Unit Total : 78.0000 Each(s)

Pick:

Qty Part Number Description Batch

78 AN960C10L Washer

11157736

BR 08-05-07

W/O:			WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)					
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 1/25/2008 10:39:20 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE HIGH GEAR 206 A/B

Job Number: 36954A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description :

43.0

D36831

INSERT



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

INSERT

batch B36319

/FL 08/05/01 ①

44.0

D34131

Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3413-1 Ring B 33949

BR

45.0

AN4C5A

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN4C5A Bolt M104936

BR

46.0

AN960C416

washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

washer

batch: M100993

BR

47.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2646 Aft Cap B37735

BR

48.0

MS27039C105

SCREW



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

SCREW

batch M107008

BR

BR 08-05-07 ①

W/O:			WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)					
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 1/25/2008 10:39:20 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE HIGH GEAR 206 A/B

Job Number: 36954A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description:

49.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

2-Install wearshoes/wearpads & Gaskets as per Dwg D3288.

3-Install Ring on Nut Plate as per detail F & Dwg D3288.

4-Spray inside tube with LPS-3 on both sides of web

M 106096

5-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive.

A/R Sikaflex-291

Sikaflex expire date:

M 107804
08-10

6-Coat all exposed fastners with LPS Procyon, remove any excess on powder coat with MEK Degreasser.

A/R LPS Procyon Batch:

M 104251

08-05-08
08-05-08

50.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/05/07

51.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-642-641

Location:

PPP Rev:

PPP 36954

8/5/22

SD

52.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/23

Job Completion



MF 08-05-22

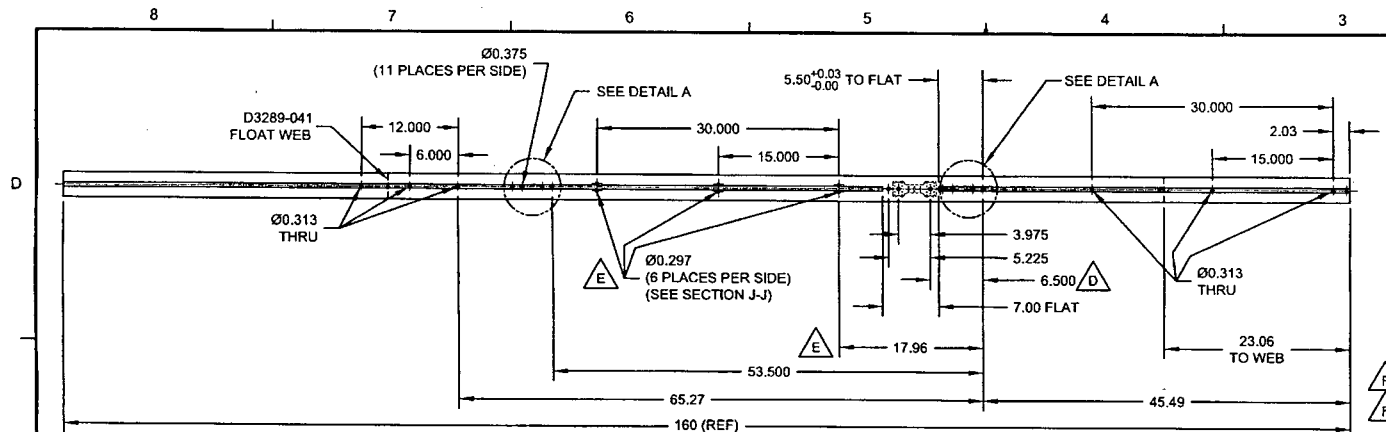
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

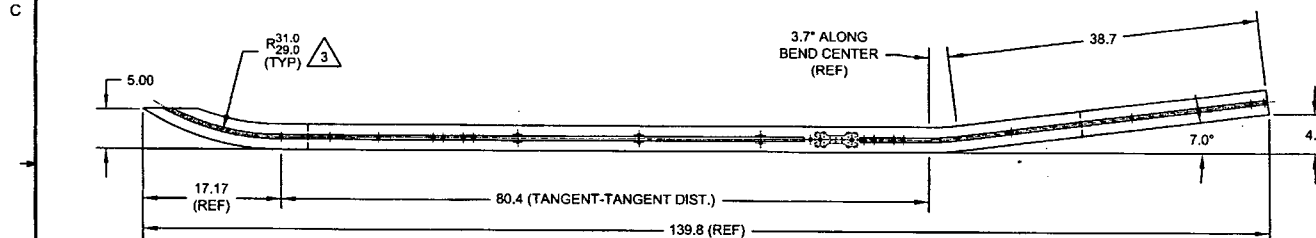
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

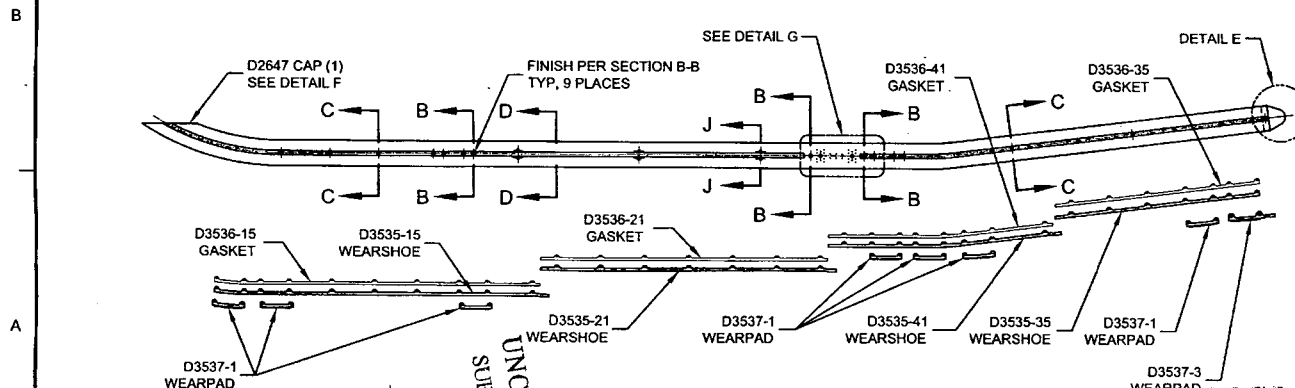
NOTE: Date & initial all entries



D3288-041 DRILLING/WEB ASSEMBLY DETAIL



D3288-041 BENDING DETAIL



D3288-041 WELDING DETAIL/SKIDTUBE ASSEMBLY

Qty	Part Number	Description
X	D3288-041	SKIDTUBE ASSEMBLY
1	D2600-1-240	EXTRUSION
1	D2646	APT CAP
1	D2647	CAP
9	D2649	CROSS BOLT SPACER
6	D3275-1	CROSS BOLT SPACER
2	D3286-1	DOUBLER
2	D3286-3	SPACER
1	D3289-041	FLOAT WEB
1	D3413-1	RING
1	D3415-041	NUT PLATE
1	D3535-15	WEARSHOE
1	D3535-21	WEARSHOE
1	D3535-35	WEARSHOE
1	D3535-41	WEARSHOE
1	D3536-15	GASKET
1	D3536-21	GASKET
1	D3536-35	GASKET
1	D3536-41	GASKET
7	D3537-1	WEARPAD
1	D3537-3	WEARPAD
12	D3683-1	INSERT
64	AL57-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
66	AN304A	BOLT
1	AN304A	BOLT
1	AN560CA18	WASHER
76	AN560C10L	WASHER
2	CCR264SS3-3	RIVET
2	CR3212-4-03	RIVET
52	CR3212-4-04	RIVET
12	MS27039C1-05	SCREW (or AN303A BOLT)
2	NAS1515H3L	WASHER

GENERAL NOTES:

1. FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
2. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
3. DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
4. BOND D3289-041 FLOAT WEB INTO D3288-1 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. ALL HOLES DRILLED ON CENTERLINES.
6. DRILL Ø0.297 HOLES FOR D3683-1 INSERTS BEFORE FINISH. INSTALL D3683-1 INSERTS AFTER FINISH.
7. DRILL Ø0.297 HOLES FOR AL57-1032-130 INSERTS USING DT3288-1T2 BEFORE FINISH. INSTALL AL57-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX-241/291.
8. TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
9. UNITS: INCHES UNLESS OTHERWISE NOTED.
10. WELDING: PER DART QSI 004.

F	SUBSTITUTE FLOAT BAG INSERT W/SPEC CTRL DWG WAS AL57-1032-130; IS NOW D3683-1	DC	07.11.21
E	MID-FLOAT HOLES WERE MOVED 2.00" FWD AND ROTATED INBOARD AND OUTBOARD BY 17" INSERTS ARE NOW INSTALLED AT THESE LOCATIONS	MB	07.09.14
D	DIMENSIONS ADDED	DC	07.06.04
C	NEW INSERTS, SS WEARSHOES AND GASKETS	PH	06.12.19
B	CHANGE INSERTS	CP	05.03.18
A	NEW ISSUE	CP	04.05.17
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN	90		
CHECKED	PC		
MFG. APPR.	PC		
APPROVED	PC		
DE APPR.	PC		
DATE	07.11.21		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3288 TITLE SKIDTUBE ASSEMBLY SCALE 1:15 REV. F SHEET 1 OF 2 COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

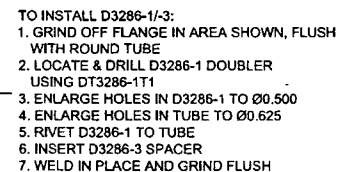
NO. 28454A
WORK ORDER
UNCONTROLLED COPY
SUBMIT TO AMENDMENT
WITHOUT NOTICE
OP COPY
RETURN TO
ENGINEERING

RELEASED
07.12.19



1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D2647 (TRIM AS NECESSARY)
 4. WELD D2647 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

DETAIL F: END FINISHING DETAIL



SECTION H-H
NOT TO SCALE

DESIGN	90	DART AEROSPACE LTD	
DRAWN	OK	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. F
MFG. APPR.	ES	D3288	SHEET 2 OF 2
APPROVED	MS	TITLE	SCALE
DE APPR.	EF	SKIDTOBE ASSEMBLY	1:3
DATE	07.11.21	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD	

Peter Hum

From: David Shepherd [dshepherd@dartaero.com]
Sent: April 25, 2008 12:33 AM
To: 'Peter Hum'
Cc: 'Chris Provencal'
Subject: RE: D206-642-641 float skidtube and D206-642-141 skidtube

There is no reason to c'bore that hole on -641.
 OK to sign off a deviation for existing production and update the drawing for the future.

David

From: Peter Hum [mailto:phum@dartaero.com]
Sent: Thursday, April 24, 2008 9:09 AM
To: David Shepherd
Cc: 'Chris Provencal'
Subject: D206-642-641 float skidtube and D206-642-141 skidtube

David,

Dan Paquette in landing gear noticed an inconsistency between the D206-642-641 float skidtube (D3288-041) and D206-642-141 skidtube (D2650-1):

- a) On D2650-1, the hole immediately forward of the 2 GHW holes that protrude out of the skidtube is NOT C'BORED (see attached)
- b) On D3288-041, the same hole IS C'BORED (see attached)

I did some digging with ChrisP and found out that we have a D206-651 GHW kit that uses the above hole. A D2711 pin goes thru at this location and I think a c'bore would NOT be necessary. Production has been making the D206-642-641 float skidtube WITHOUT the c'bore and it has been shipped to customers.

There is a few D206-642-641 in production, and they are wondering if this hole needs to still be c'bored because that was what they previously have been doing (this problem was only discovered now)

I think we should do the following:

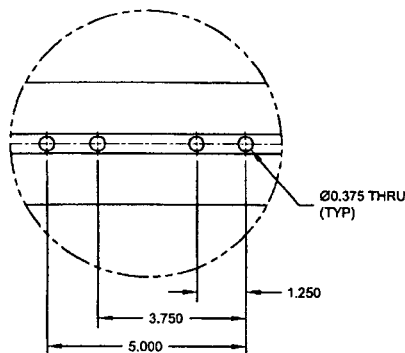
- a) Allow the hole to be NOT C'BORED (i.e. sign a deviation)
- b) Update the drawing to remove the C'BORE

I don't think this will affect anything that has been shipped because the D2711 will still fit and perform as intended.

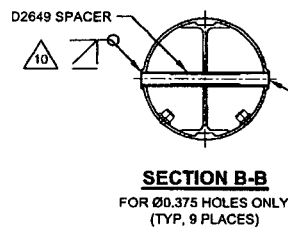
Is there a specific reason why the float skidtube needs the C'bore but not on the std. skidtube? (I think this detail was missed on the drawing updates of the D3288)

What do you think? Have I missed something?

Peter Hum
 Mechanical Designer
 Dart Aerospace Ltd.
 1270 Aberdeen St.
 Hawkesbury, ONT, K6A 1K7
 Tel: (613) 632-5200
 Fax: (613) 632-9311



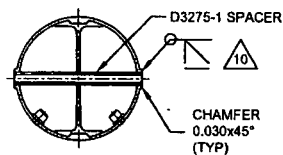
DETAIL A: DRILL DETAIL



AFTER DRILLING AND BENDING ASSEMBLY, PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:

1. CHAMFER HOLE 0.030x45°
2. INSERT D2649 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. CBORE TO Ø0.313x0.75 DEEP

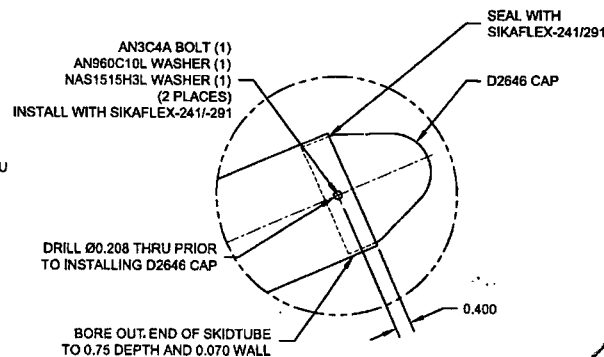
SECTION B-B
FOR Ø0.375 HOLES ONLY
(TYP, 9 PLACES)



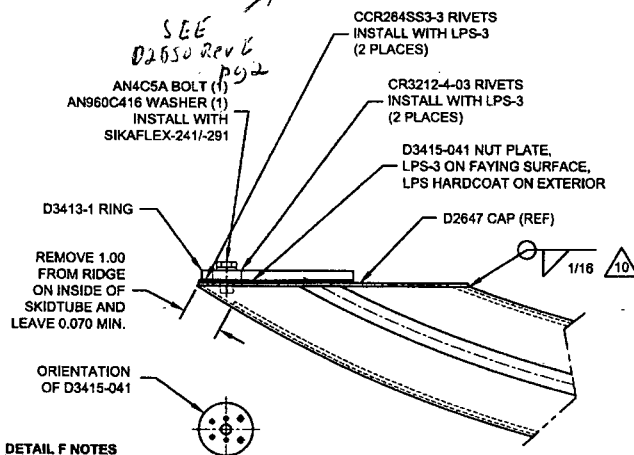
SECTION C-C
FOR Ø0.313 HOLES ONLY
(TYP, 6 PLACES)



SECTION D-D
FOR WEARSHOES INSTALL ONLY
(TYP, 32 PLACES)



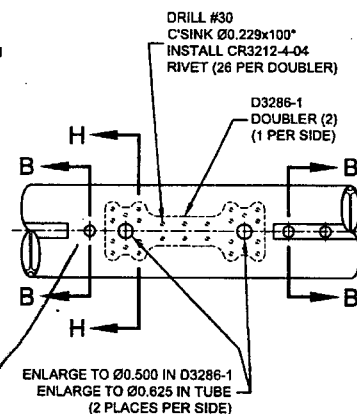
DETAIL E



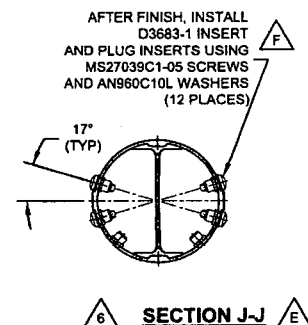
DETAIL F NOTES

1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D2647 (TRIM AS NECESSARY)
 4. WELD D2647 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041 PRIOR TO FINISH

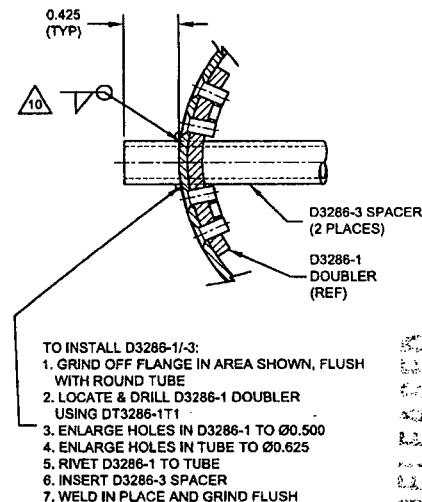
DETAIL F: END FINISHING DETAIL



DETAIL G
SCALE 1:5



SECTION J-J



SECTION H-H
NOT TO SCALE

DESIGN	90	DART AEROSPACE LTD	
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PR	DRAWING NO.	REV. F
MFG. APPR.	KG	D3288	SHEET 2 OF 2
APPROVED	KG	TITLE	SCALE
DE APPR.	KG	SKIDTUBE ASSEMBLY	1:3
DATE	07.11.21	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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NO. 151

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barday Elliott
Job number: 206642644 36962A
Part number: 206642641
Description: 206 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual:
Penetration:

pass[☒] fail[]
pass[☒] fail[]

UNACCEPTABLE

Cracks:
Undercut:
Pin holes:
Overlap (cold lap)
Porosity (surface):
Coloration:

pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]

Qualifier Pgt. Dupal Date of Test Coupon 08-04-23
Welder Barday Elliott Date of Test Coupon 08-04-23

The above named individual is qualified in accordance with AWS D17.1.2001 to weld